

## CLAIMS

Claims 1-27 (canceled)

Claim 28 (currently amended): A method for forming a hydroform, comprising:

providing a first tubular structure having an outer surface;

disposing an adhesive structural material upon the outer surface with an applicator wherein the adhesive structural material includes epoxy;

providing a second tubular structure having an inner surface defining a bore;

hydroforming the first tubular structure while the adhesive structural material is located upon the outer surface thereby forming a hydroformed contour of the first tubular structure with the adhesive structural material located upon the contour; and

adhering the adhesive structural material to the inner surface of the second tubular structure.

Claim 29 (canceled )

Claim 30 (currently amended): A method as in claim 28 wherein the step of hydroforming occurs while at least a portion the first tubular structure and the adhesive structural material are located within the open bore of the second tubular structure.

Claim 31 (canceled )

Claim 32 (canceled)

Claim 33 (currently amended): A method as in claim 28 wherein the adhesive structural material ~~expandable material~~ is epoxy-based.

Claim 34 (currently amended): A method as in claim 28 29 wherein the second tubular structure is metal.

Claim 35 (previously presented): A method as in claim 34 wherein the second tubular structure is formed of aluminum or steel.

Claim 36 (previously presented): A method as in claim 28 further comprising:  
assembling the first tubular structure to a vehicle as a portion of a frame of the vehicle.

Claim 37 (canceled)

Claim 38 (previously presented): A method as in claim 28 wherein the adhesive structural material is activated for curing at a temperature in the range of about 148.89 °C to about 204.44 °C.

Claim 39 (currently amended): A method as in claim 28 29 wherein the adhering step is performed prior to the step of hydroforming.

Claim 40 (currently amended): A method for forming a hydroform, comprising:  
providing a first structure having an inner surface defining an open bore;  
providing a second structure having an outer surface;  
positioning an adhesive structural material within the open bore of the first structure between the inner surface defining the bore and the outer surface of the second structure; ~~and~~  
hydroforming the first structure and second structure while at least a portion of the structural material is located in the open bore wherein the hydroforming includes injecting a liquid under pressure into the bore such that an outer surface of the first structure assumes a shape of a mold; and

adhering the adhesive structural material to the inner surface defining the bore and to the outer surface of the second structure.

Claim 41 (canceled)

Claim 42 (previously presented): A method as in claim 40 wherein the first structure is tubular.

Claim 43 (previously presented): A method as in claim 40 wherein the second structure is tubular.

Claim 44 (currently amended): A method as in claim 40 wherein the step of positioning the adhesive structural material within the open bore of the first ~~outer tubular~~ structure includes disposing the adhesive structural material upon the outer surface of the second ~~inner tubular~~ structure.

Claim 45 (currently amended): A method as in claim 40 wherein the adhesive structural material is expandable at a temperature greater than a [its] glass transition temperature of the adhesive structural material ~~expandable material~~.

Claim 46 (currently amended): A method for forming a reinforced hydroform automotive vehicle frame structure, comprising:

providing an outer elongated metal tubular structure having an inner surface defining an open bore;

providing an inner elongated metal tubular structure having an outer surface;

applying an adhesive structural material to at least one of the inner surface defining the open bore and the outer surface of the inner tubular structure;

introducing the adhesive structural material within a space defined between the inner surface of the outer tubular structure and the outer surface of the inner tubular structure; and

hydroforming the outer tubular structure and the inner tubular structure with the adhesive structural material therebetween to form the automotive vehicle frame structure and for forming a first hydroformed contour in the inner tube and a second hydroformed contour in the outer tube wherein the first hydroformed contour is adjacent to and corresponding with the second hydroform contour and at least a portion of the expandable material is located between the first hydroformed contour and the second hydroformed; and

bonding the adhesive structural material to at least one of the tubular structures wherein the bonding is performed prior to the step of hydroforming;

wherein the hydroforming includes injecting a liquid under pressure into the bore such that an outer surface of the outer structure assumes a shape of a mold; and

wherein the adhesive structural material is epoxy based.

Claims 47-49 (canceled)

Claim 50 (previously presented): A method as in claim 29 wherein the hydroforming includes injecting a liquid under pressure into the bore such that an outer surface of the first structure assumes a shape of a mold.

Claim 51 (new): A method as in claim 40 wherein the adhesive structural is epoxy-based.

Claim 52 (new): A method as in claim 40 wherein the second structure is metal.

Claim 53 (new): A method as in claim 52 wherein the second structure is formed of aluminum or steel.

Claim 54 (new): A method as in claim 40 further comprising:

assembling the first structure to a vehicle as a portion of a frame of the vehicle.

Claim 55 (new): A method as in claim 40 wherein the adhesive structural material is activated for curing at a temperature in the range of about 148.89 °C to about 204.44 °C.

Claim 56 (new): A method as in claim 40 wherein the adhering step is performed prior to the step of hydroforming.

Claim 57 (new): A method as in claim 46 wherein the adhesive structural material is expandable at a temperature greater than a glass transition temperature of the adhesive structural material.

Claim 58 (new): A method as in claim 46 wherein the outer tubular structure is formed of aluminum or steel.

Claim 59 (new): A method as in claim 46 further comprising:

assembling the outer tubular structure to a vehicle as a portion of a frame of the vehicle.